

Work Order ID: **93848**

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93848

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Item ID: D2872-045
 Revision ID:
 Item Name: Nut Plate Assembly
 Start Date: 22/11/2012 Start Qty: 30.00
 Required Date: 06/12/2012 Req'd Qty: 30.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12-11-22 Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2872	Rev A								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 0.750" x 0.375" x 2.700" long								
			<u>FL</u>	<u>12/11/26</u>		<u>30</u>	<u>0</u>		
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA550 and Dwg D2872 Identify as D2872-5 Dwg Rev <u>A</u> Folio Rev <u>AA</u>								
			<u>B.A</u>	<u>12/11/27</u>		<u>30</u>	<u>0</u>		<u>DAS</u> <u>08</u> <u>9-88</u>
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
			<u>B.A</u>	<u>12/11/27</u>		<u>30</u>	<u>0</u>		<u>DAS</u> <u>08</u> <u>9-88</u>

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Item ID: D2872-045
 Revision ID:
 Item Name: Nut Plate Assembly
 Start Date: 22/11/2012 Start Qty: 30.00
 Required Date: 06/12/2012 Req'd Qty: 30.00
 Reference:

Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		22.11.28		30	4		DAS 04 9-89
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2872	0.00 0.00				30x			2/12/03
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		121203		30			DAS 15 8-89 CenA

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Item ID: D2872-045
Revision ID:
Item Name: Nut Plate Assembly

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 22/11/2012 Start Qty: 30.00 ***30***
Required Date: 06/12/2012 Req'd Qty: 30.00 ***30***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Chemical Conversion Coat per QSI005 4.1 0.00

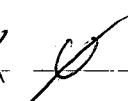
160

HandFinish

Hand Finishing

Memo

0.00

30X  12/12/03

170 QC3- Inspect Part Finish 0.00


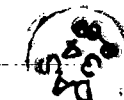
170

QC

Quality Control

Memo

0.00

30  12-12-3. 

180 Small Fab 0.00

180

Small Fab


Small Fab

Small Fab

Memo

0.00

1-Assemble as per Dwg D2872 2-Identify as D2872-045

30x  12/12/27

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Item ID: D2872-045
Revision ID:
Item Name: Nut Plate Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 22/11/2012 Start Qty: 30.00 ***30***
Required Date: 06/12/2012 Req'd Qty: 30.00 ***30***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200 Identify as per dwg & Stock Location: **ST020** 0.00

200

Packaging

Memo

0.00

Packaging

210 QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.00

Quality Control

30
can

20X

50
13-227

13/2/28

MCS 13-02-28

Picklist Print

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Page 1

Work Order ID: 93848

93848

Parent Item: D2872-045

D2872-045

Parent Item Name: Nut Plate Assembly

Start Date: 22/11/2012

Required Date: 06/12/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21086L5		Purchased	No			100	Each	15.0000	2	60			
-----------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

MS21086L5

Nut Plate

Location

Loc Qty

Loc Code

ST319

15

102728

15

M6061T6B0.375X00.75
0

Purchased

No

180

f

15.7726

0.225

7.105263

M6061T6B0.375X00.750

6061T6 BAR .375 x .750

6061T6 Bar .375 x 1.600 (This batch only)

Location

Loc Qty

Loc Code

MAT001

15.7726312

113719

2.45

117653

13.3226312

MS20426AD4-5

Purchased

No

180

Each

4,031.000

4

120

MS20426AD4-5

Rivet

Location

Loc Qty

Loc Code

ST317

4031

6874

4031

PS.3/02/27
M124525
M123900



123 279

**

7.106 Fk 12/11/26

Could not pull!

120 PS.3/02/27

DART AEROSPACE LTD		Work Order:	93848
Description: Radius Block		Part Number:	D2872-5
Inspection Dwg: D2872	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

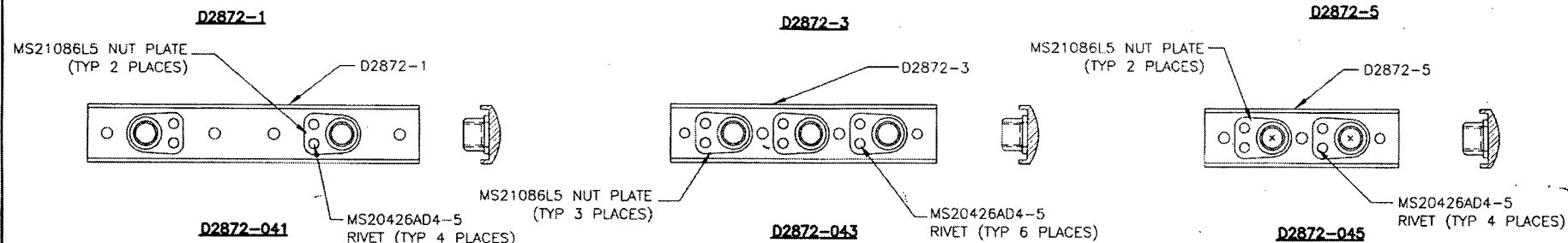
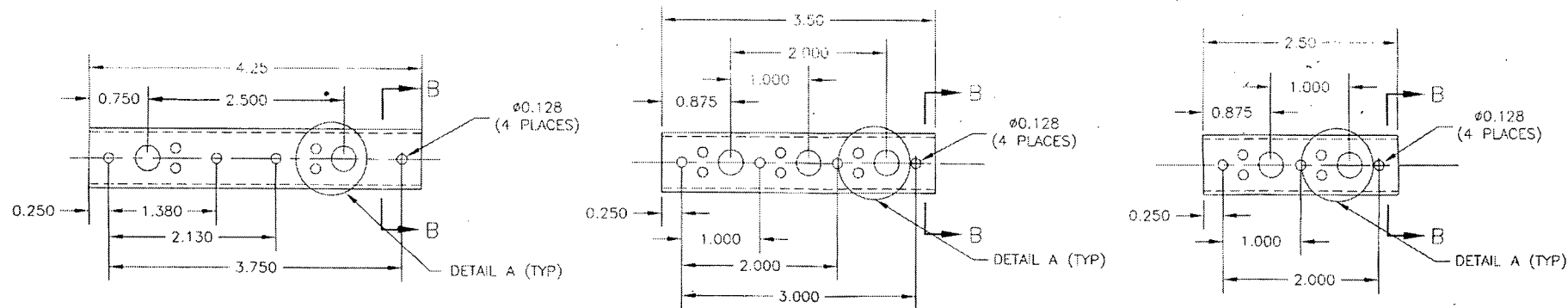
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.502	✓		Vern	GA-01
1.000	+/-0.010	1.000	✓		"	"
0.875	+/-0.010	0.876	✓		"	"
0.250	+/-0.010	0.251	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø0.129	✓		"	"
0.269	+/-0.010	0.269	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.317	✓		"	"
0.750	+/-0.010	0.750	✓		"	"
0.650	+/-0.010	0.644	✓		"	"
R0.02	+/-0.030	R0.010	✓		R-6	REF.
0.141	+/-0.010	0.142	✓		Vern	GA-01
Ø0.230 x 0.125 0.050	+0.005/-0.001 x 0.010	Ø0.230 x 0.050	✓		Vern/H-6	GA-01/31006

AFS
12/11/27

Measured by: <u>Da</u> ^{DAS} 08	Audited by: <u>Ref</u> ^{DAS} 04	Prototype Approval:	N/A
Date: <u>12/11/27</u> ²⁻⁸⁹	Date: <u>11. R. 20</u> ²⁻⁸⁹	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue P/O D2872-045	KJ/JLM	<u>BE</u>



D2872-1/-3/-5 RADIUS BLOCK

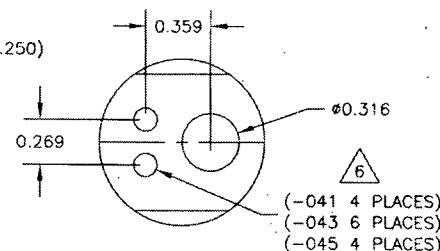
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B0.750X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B0.750X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.050$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100$

D2872-041/-043/-045 NUT PLATE ASSEMBLY

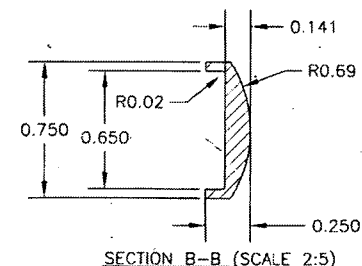
- 1) INSTALL MS21086L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-5 RIVETS

D2872-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2872-041	NUT PLATE ASSEMBLY
	X		D2872-043	NUT PLATE ASSEMBLY
		X	D2872-045	NUT PLATE ASSEMBLY
1			D2872-1	RADIUS BLOCK
	1		D2872-3	RADIUS BLOCK
		1	D2872-5	RADIUS BLOCK
4	6	4	MS20426AD4-5	RIVET
2	3	2	MS21086L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED
05.07.26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	DS	APPROVED DS
DATE	05.07.26	TITLE RADIUS BLOCK
		DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D2872
		SHEET 1 OF 1
		SCALE 4:5

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 93848-MLJ

12-11-22